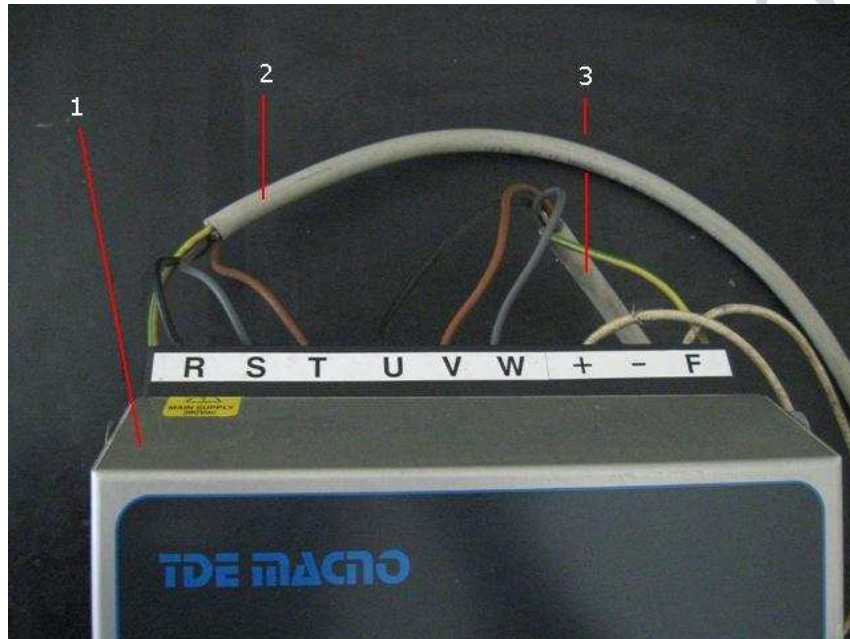


## What to do if the replaced electric spindle does not orientate and/or cannot reach the set up speed

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- Verify the good connections and the groundward continuity of the spindle power cable (3), of the network cable 3x380V 50/60Hz (2) and of the encoder cable – Pic. 1
- Verify if the digital monitor of the spindle rotation, located on the inverter (1), can read the peripheral speed, turning manually the spindle shaft both clockwise (+) or anti-clockwise (-).
- Verify the correct inverter (1) adjustment. Pic. 1
- Verify the spindle rotation sense: the encoder can read only and exclusively in the set up rotation sense. To reverse the spindle rotation sense is sufficient to change the position of the wire (U) with the wire (V) or the wire (V) with the wire (W) or the wire (U) with the wire (W) of the spindle power cable (3) from the inverter exit (1) – Pic. 1
- Replace the encoder circuit board and the encoder reader in according to our procedure downloadable on our web site [www.srdev.eu](http://www.srdev.eu/Guide/Howto%20replace%20the%20encoder%20on%20elm%20HSD%20ES710E%20ISO40.pdf) executing the following link: <http://www.srdev.eu/Guide/Howto%20replace%20the%20encoder%20on%20elm%20HSD%20ES710E%20ISO40.pdf>.
- Contact SRD technical dept +39 347 6011256.